

Work Order ID 117799

May-05-14 8:12:05 AM

117799

Page 1

Item ID: D3066-1

Revision ID:

Item Name: Spacer

Start Date: 5/05/14

Required Date: 5/19/14

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MCS

Date: 140505

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3066

Rev B

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3066

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

167 0 Jm14-05-6

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

167 0 Jm14-05-6

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

DAS
27
9-89

14/5/17

167

can

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Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 5/05/14 **Start Qty:** 160.00

160

Cust Item ID:

Required Date: 5/19/14 **Req'd Qty:** 160.00

160

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------------|---------------|------------------|----------------|
|---------------|---------------|------------------|----------------|

Chemical Conversion Coat per QSI005 4.1

0.00

130

Memo

0.00

HandFinish

Hand Finishing

QC7-Inspect Chemical Conversion Coat

0.00

140

Memo

0.00

QC

Quality Control

Identify as per dwg & Stock Location: WA003 0.00

0.00

150

Memo

0.00

Packaging

Packaging

*** STOCK IN STEP CELL***

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Item ID: D3066-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 5/05/14

Start Qty: 160.00

160

Cust Item ID:

Required Date: 5/19/14

Req'd Qty: 160.00

160

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 14-05-09

14-05-08

Picklist Print

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Work Order ID: 117799

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Parent Item: D3066-1

D3066-1

Parent Item Name: Spacer

Start Date: 5/05/14

Required Date: 5/19/14

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP: C02.11.01 Incorporated D3066-1 IPPKJ/RF
IPP Rev:B Now M6061-T6 06-06-23 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.080 | | Purchased | No | | | 100 | sf | 489.4600 | 0.0945 | 16 | | | |
| *M6061T6S 080* | | | | | | | | | | ** | | Jm14-05-6 | |
| 6061-T6 .080 Sheet | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

MAT021

489.46

m126309

130.52

m126350

14.26

m128408

8.68

m128903

336

128903

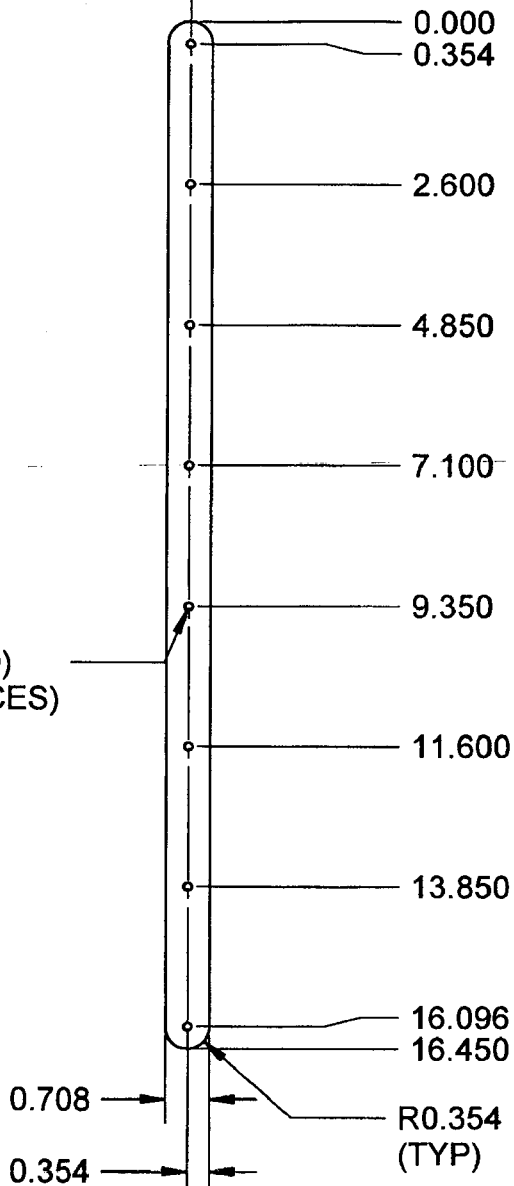


| | | | |
|----------------------|--------------------------------|---|------------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3066 | REV. B |
| DATE 06.05.29 | | TITLE SPACER | SHEET 1 OF 1 SCALE 1:3 |
| A | 02.09.11 | NEW ISSUE | |
| B | 06.05.29 | ADD 6061-T6 MATERIAL | |

RELEASED

de. de. 20 *[Signature]*

Ø 0.128 (#30)
(TYP 8 PLACES)



D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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